

Work Order ID 117320

June-16-14 10:54:27 AM

117320

Page 1

Item ID: D4807-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Assembly
 Start Date: 6/16/14 Start Qty: 2.00 *?
 Required Date: 6/16/14 Req'd Qty: 2.00 *?
 Reference: PART MARKING Cust Item ID:
 Customer:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	DAS							
D4807	REVA <u>B</u>	27 9-89							
115		14/6/20							
115									
Purchasing	Memo	0.00							
Purchasing	PULL FROM STK: 2 X D4807-041 B111664 SEND TO P & L PRINTING FOR PART MARKING PO <u>24622</u>								
121	Receive & Inspect for Damage & Mat'l Certs	0.00							
121									
Packaging	Memo	0.00							
Packaging									
128	QC6- Inspect dimensions to drawing	0.00							
128									
QC	Memo	0.00							
Quality Control									

CL 14/10/17

2014/6/18 (2)

DAS
27
9-89
14/6/20

2

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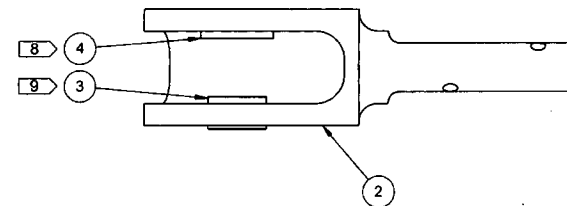
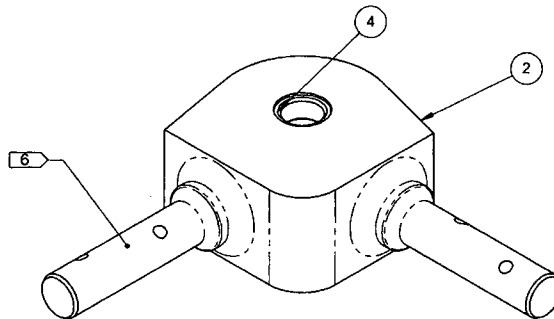
Item ID: D4807-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Assembly
 Start Date: 6/16/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/16/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference: PART MARKING

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST/D2</u>	0.00							
130									
Packaging	Memo	0.00				2X		14-6-20	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				MLJ		14-06-24	
Qualify Control									

14-06-20

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
1	X	D4807-041	SUPPORT ASSEMBLY
2	1	D4807-1	SUPPORT
3	1	NAS75C6-009	BUSHING
4	1	NAS77C6-017	BUSHING



D4807-041 SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.59 lbs
- 8) NAS77C6 BUSHING IS PRESS FIT
- 9) NAS75C6 BUSHING IS SLIDE FIT

A NEW ISSUE		RF	13.09.16
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4807	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SUPPORT ASSEMBLY	NTS
DATE	13.12.30	COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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plprinting@bellnet.ca

PACKING SLIP

SOLD TO

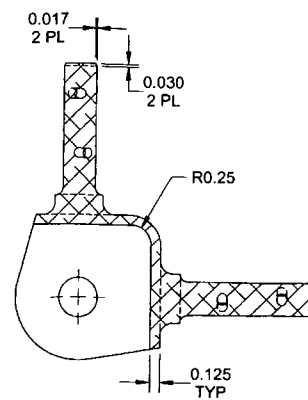
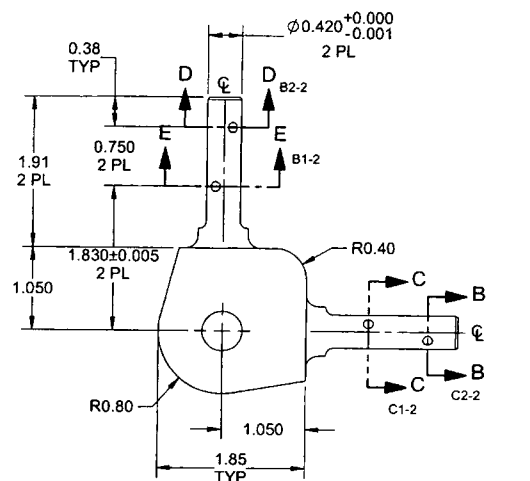
DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

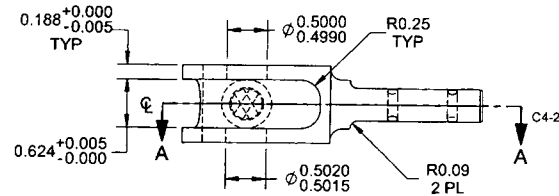
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1270 ABERDEEN
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CANADA

P.O NUMBER PO24622

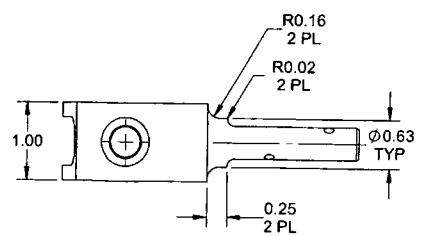
ITEM DESCRIPTION	QUANTITY	COMMENTS
D4880-042 LEG ASSEMBLY	1	ALL ITEMS HAVE BEEN LASER MARKED
D4881-041 LEG ASSEMBLY	1	
D4881-042 LEG ASSEMBLY	1	
D4882-041 LEG ASSEMBLY	2	
D4880-041 LEG ASSEMBLY	1	
D4803-1 STRUT	1	
D4871-3 END FITTING EYE	11	
D4866-2 STRUT	2	
D4882-1 STRUT	3	
D4866-1 STRUT	2	
D4928-1 STRUT	4	
D4807-041 SUPPORT ASSEMBLY	2	
D4878-1 STRUT	1	
D4867-1 STRUT	4	
D4868-1 STRUT	4	
D4884-1 END FITTING EYE	8	
D4884-3 END FITTING EYE	5	
D4801-1 STRUT	1	
D4804-1 STRUT	2	
D4806-1 CLEVIS	2	
D4806-3 STUD	8	
D4879-1 STRUT	2	



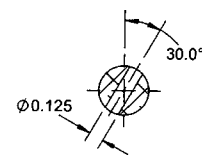
SECTION A-A B6-2



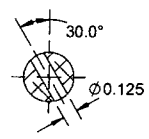
SECTION B-B C6-2



SECTION C-C C6-2



SECTION D-D D7-2



SECTION E-E D7-2

D4807-1 SUPPORT

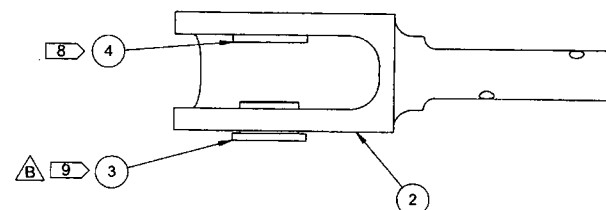
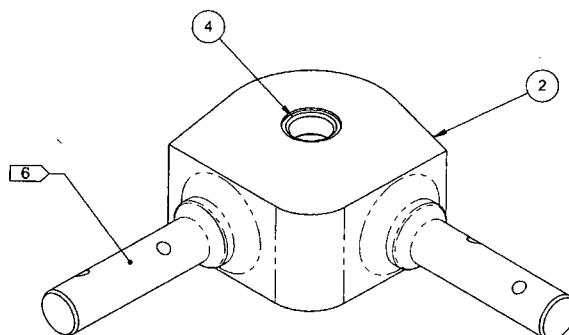
RELEASE
2014-06-16

- NOTES:
- 1) MATERIAL: 17-4 PH STAINLESS STEEL BAR, H900 CONDITION
PER AMS 5604/5643
DART SPEC M17-4-B
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.57 lbs
 - 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D4807	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SUPPORT ASSEMBLY	NTS
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4807-041	SUPPORT ASSEMBLY
2	1	D4807-1	SUPPORT
3	1	D5113-1	BUSHING
4	1	NAS77C6-017	BUSHING



D4807-041 SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.59 lbs
- 8) NAS77C6-017 BUSHING IS PRESS FIT ON $\phi 0.500$ HOLE
- 9) D5113-1 BUSHING IS SLIDE FIT ON $\phi 0.502$ HOLE

RELEASED
2014-06-16

B	D5113-1 WAS NAS75C6-009 (ZN D3-1, B4-1, A8-1); REVISE NOTE 8 & 9 (ZN A8-1)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	14.04.08		

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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4807** REV. B
SHEET 1 OF 2
TITLE **SUPPORT ASSEMBLY** SCALE NTS

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